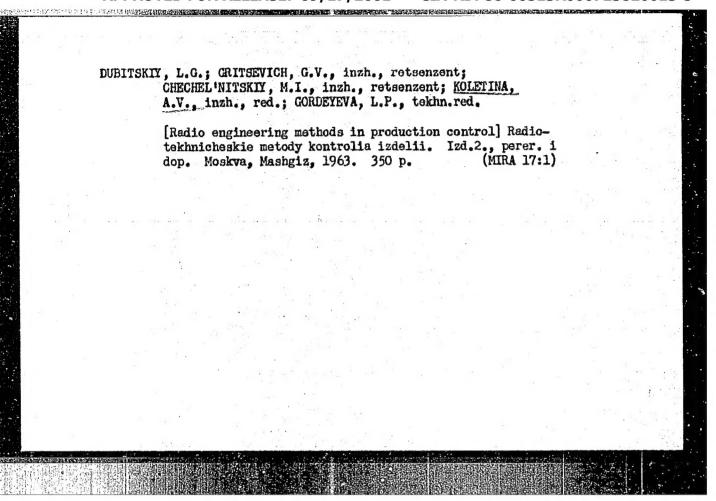
DUBITSKIY, L.G.; CRITSEVICH, G.V., inzh., retsenzent; CHECHEL'NITSKIY, M.I., inzh., retsenzent; KOLETINA, A.V., inzh., red.; GORDEYEVA, L.P., tekhn. red.

[Radio methods of production control] Radiotekhnicheskie metody kontrolia izdelii. Izd.2., perer. 1 dop. Moskva, Mashgiz, 1963. 350 p. (MIRA 17:3)



# KOLETIRKIN, I.

"Conditions of Moscom's gas supply and its perspectives; also, remarks by B. Mory and F. Valy."

p. 420 (Energia Es Atomtechnika) Vol. 10, no. 8/10, Dec. 1957 Budapest, Hungary

SO: Monthly Index of East European Accessions (EEAI) LC. Vol. 7, no. 4, April 1958

#### KOLETSKAYA, M.L.

Biology of vipers. Priroda 45 no.5:101-102 Ky '56. (MERA 9:8)

1. Dervinskiy zapovednik. (Serpents)

APPROVED FOR RELEASE: 09/17/2001 CIA-RDP86-00513R000723820013-5

POLAND / Acoustics. Electroacoustics and Engineering Acoustics.

Abs Jour : Ref Zhur - Fizika No 3, 1957, No 7526

Author

: Dryanskiy, Koletskiy

Title

: Recording of Sound on Color Film Copies

Orig Pub : Kinotechnik, 1956, 9, No 96, 1973-1975

Abstract : A popular description of the features of the "phonogram" obtained by various methods of production of colored motion picture films.

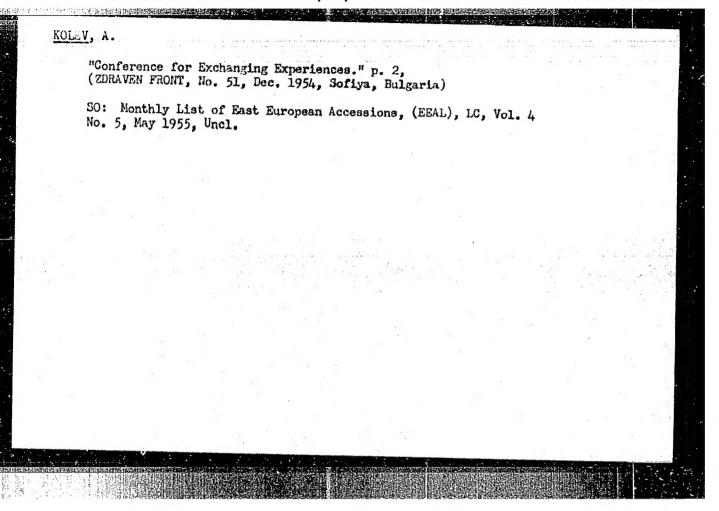
Card : 1/1 Experience Gathered by an Oxygen Station of the Yefremov Plant SK

SOV/67-58-4-7/29

preparation and distribution of the lye solution in both apparatus. From the table in which the cutputs attained by these devices are compared it may be seen that, after the aforementioned changes and improvements had been carried out at this oxygen station, the duration of periods of operation (1440 instead of 480 hours) and also the periods during which oxygen was extracted (1397 instead of 428 hours) were approximately increased to treble their former amount. The useful coefficient of work was increased from 89% to 97%. There are 1 figure and 1 table.

Card 2/2

- 1. Oxygen—Production 2. Industrial equipment—Design
- 3. Industrial equipment—Performance 4. Industrial plants—Operation



KOLEY. A.

Advantages of steam boilers for ships. p.44. (TRANSPORTNO DELO Vol. 7, no. 6, 1955, Sofiya)

SO: Monthly List of East European Accessions, (EEAL). LC, Vol. 4, No. 11, Nov. 1955, Uncl.

KOLEV, A.

"Causes of the breaking of springs of railroad cars and methods for their elimi-

p.19 (Transportno Delo, Vol. 10, no. 3, 1958, Sofiia, Bulgaria)

Monthly Index of East European Accessions (EEAI) LC, Vol. 7, No. 8, August 1958

1.	KOLEV.	4 53
1.	LOTEA -	A.F.

- 2. USSR (600)
- 4. Docks
- 7. Sectional method for constructing the hulls of reinforced concrete unloading platforms, Rach.transp. 13 no. 2, 1953.

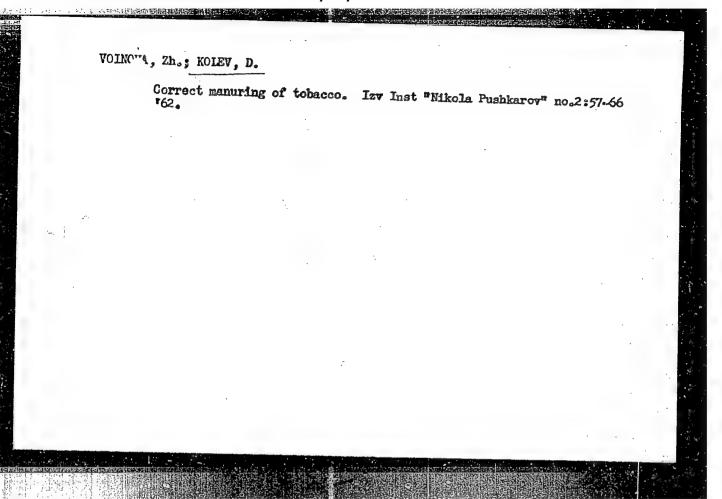
9. Monthly List of Russian Accessions, Library of Congress, APRIL 1953, Uncl.

KOLEV, C.

Determination of the composition of concrete. p. 1.

Vol. 2, no. 6, 1955 STROITELSTVO Sofiya, Bulgaria

So: Eastern European Accession Vol. 5 No. 4 April 1956



KOLEY DIMITUR

DULGARIA/Cultivated Plants. Cereals.

Abs Jour: Ref Zhur-Diol., No 17, 1958, 77590.

Author : Popov, Favel; Kolev, Dimithr

Hast : Ministry of Agriculture and Forestry.

Title : Investigation of Comparative Projectivity of

Branched Wheat (Triticum turgidum compositum - Local Variety), and Soft Winter Wheat (Triticum vulgare var. ferrungineum - Okermann Variety).

Crig Pub: Nauchn. tr. M-vo zemed. i gorite. Ser. rasteniyevodstvo,

1957, 2, No 6, 1-14.

Abstract: Data of comparative experiments and investigations

of the Agricultural Scientific-Research Institute in Sofia and Chernan and of experimental stations. With all variants, the harvest of branched wheat

Card : 1/2

KOLEV, D.Kh., kand. sel'skokhoz. nauk (Narodnaya Respublika Bolgariya)

Results of vegetative and vegetative sexual hydridization of wheat with rye. Agrobiologia 5:761-765 3-0 '64. (MIRA 17:11)

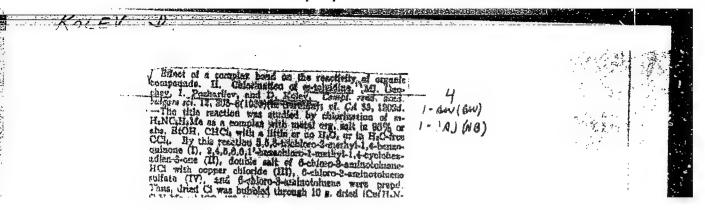
1. Vysshiy sel'skokhozyaystvennyy institut, kafedra rasteniyevodstva, Plovdiv.

KOLEV, D.: STOIANOV, V.

"Tanns in basket willows in relation to the age of the willow and the season when the bark is removed"

Khimiia i industriia. Sofiia, Bulgaria. Vol. 30, no. 3, 1958

Monthly list of East European Accessions (EEAI), LC, Vol. 8, No. 6, Jun 59, Unclas



KONSTANTINOV, L.; KOLEV, D. (Sofiya)

Preparation of ether-valerian tincture in large-scale production.

Apt. delo 10 no.3:85 My-Je '61.

(VALERIAN)

(MIM 14:7)

AKHTARDZHIYEV, Kh.; KOLEV, D. (Sofiya)

Study of the composition of a mucous substance in flores Tiliae argenteae. Apt. delo 10 no.6:78-82 N-D \*61. (MIRA 15:2)

(LIRDEN)

VARTANIAN, A.; MANOLOV, A.; PERFANOV, G.; KOLEV, D.; MILIANCHEV; GULUBOV, St.; KOSTIANEV, St.

Spring soil tilling, and its influence on the development, yield and quality of tobacco. Izv Inst tiutiun BAN 1:73-118 '61.

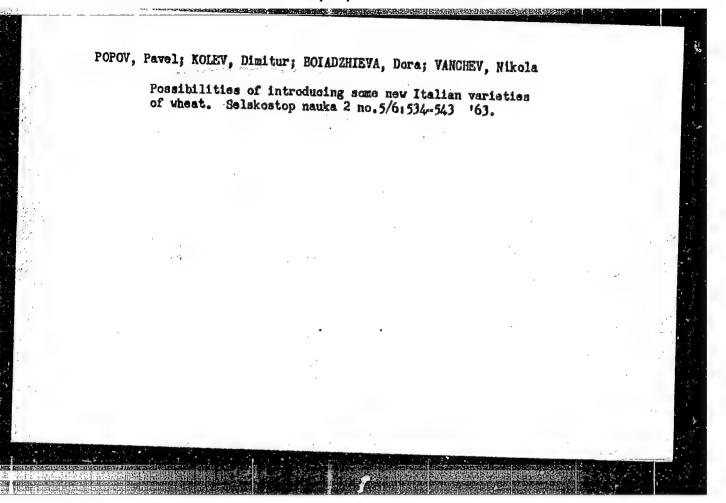
BULGARIA

BANIKOVA, S.: PAPARIZOV, A.: KOLEV, Dim.

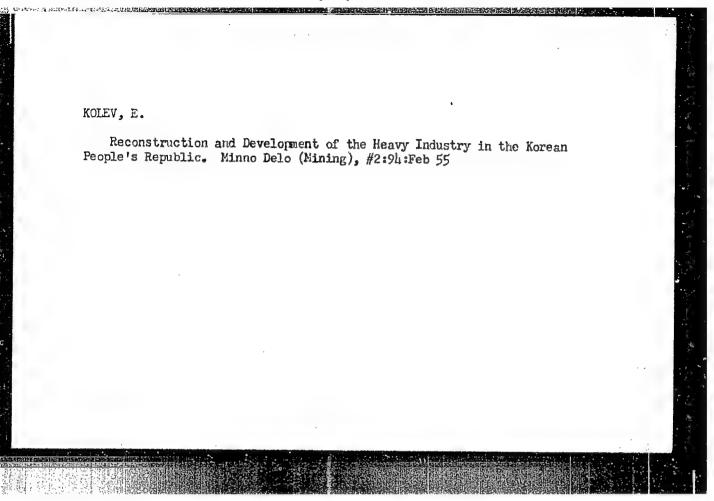
Sofia, Farmatsiya, No. 1, Jan-Feb 1963, pp 14-15

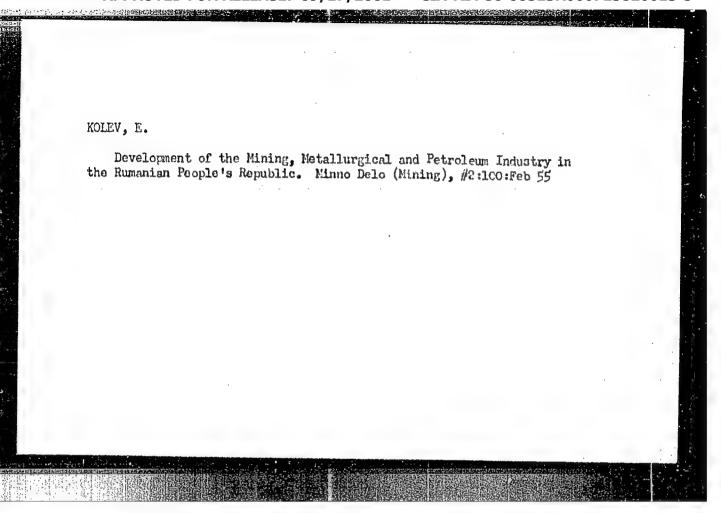
"The Increased Proteclitic Activity of Pancreas Preparation."

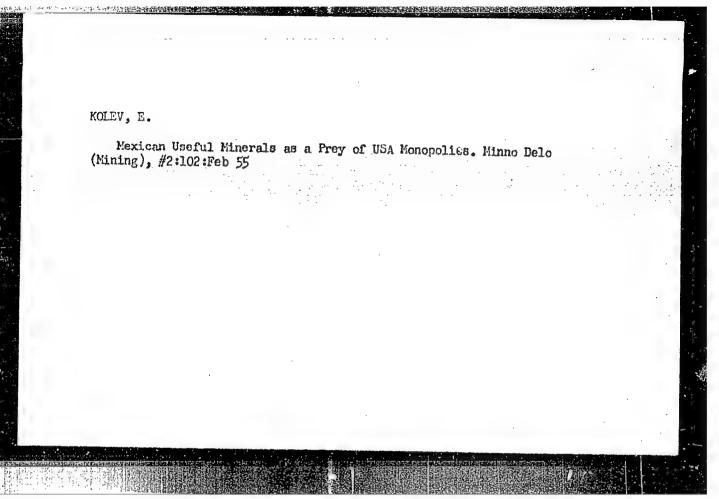
(3)

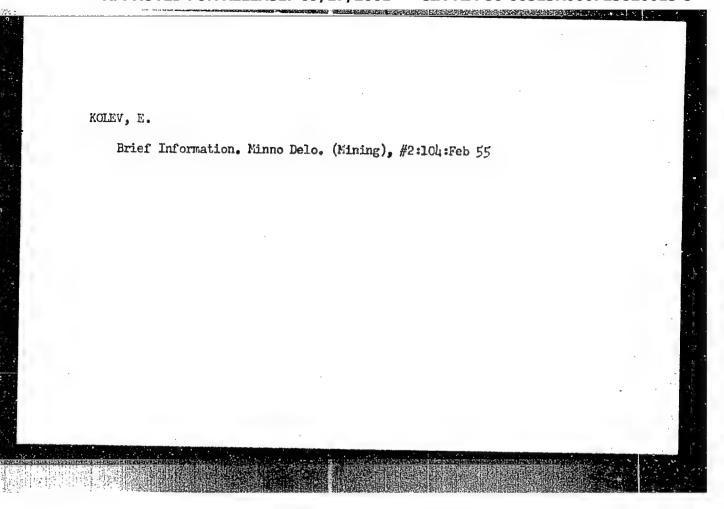


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APPROVED FOR RELEASE: 09/17/2001 CIA-RDP86-00513R000723820013-5"

KOLEV, G.

"Conditions for selecting the type of diesel locomotive to be used in Bulgaria."
p. 13. (Transportno Delo, Vol. 10, No. 4, 1958, Sofiia, Bulgaria)

Monthly Index of East European Accessions (EEAI) LC, Vol. 7, No. 12, Dec 58

KOLEY, G.

Why the mafety fackets of cylinders crack and how their use may be justified. p.21. (TRANSPORTNO DELO Vol. 7, no. 1, 1955, Sofiya)

SO: Monthly List of East European Accessions, (EFAL). LC. Vol. 4, No. 11, Nov. 1955, Uncl.

AULHY, G.

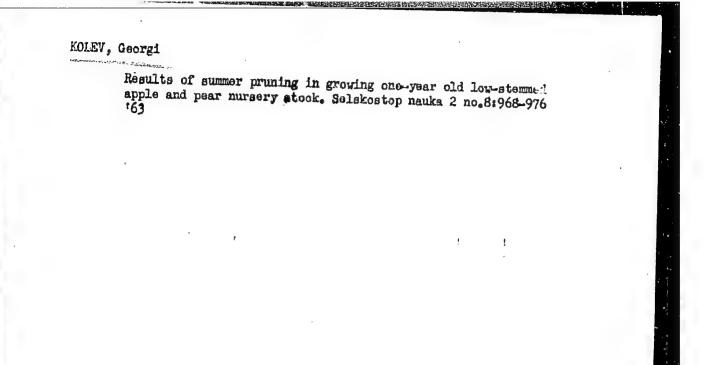
Kolev, G. Utilization of liquid fuel in steam locomotives. p. 11. TRANS-PORTNO DELO. Sofiya. Vol. 7, no. 6, 1955.

SO: Montbly List of East European Accessions, (EEAL), LC, Vol. 4, No. 11, Nov. 1955, Uncl.

KOLEV, G., inzh.

Two methane explosions abroad, and their moral. Min delo 17 no.12:41-44 D  $^{\circ}$ 62.

1. Otdel "Vuglishta, neft i gaz" pri Komiteta po promishle-



VASILEV, Vasil, inzh.; KOLEV, Georgi, inzh.

Results from the use of new types of irrigation equipment. Khidrotekh i melio 7 no.10:314-315 '62.

A symposium on the use of herbicides. Selskestop nauka 1 no.7/8:882-883 162.

# KOLEV, IV.

On the prospectives of new deposits of coal in the Balkan Mountains Coal Field. Min delo 16 no.11:3-7 '61.

1. Gl. geolog na Balkanskata prouchvatelna brigada.

(Coa1)

BULGARIA/Weeds and Their Control.

N.

Abs Jur Ref Zhur - Biol., No 15, 1958, 68463

> cultivation. Of the annual weeds the varieties with a longer vegetative period were most effectively removed through soil cultivation, giving way to species which form seeds rapidly. -- O.P. Medvedeva

Card 2/2

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COUNTRY

BULGARIA

CATEGORY

Wasds and Weed Control.

H

APS. JOUR. : RZhBicl., No. 3, 1959, No. 11204

AUTHOR

Kolev. I. D.

INET.

Institute of Flant Growing, Bulgarian AS.

TITLE

: Weeds of the Pulse Family Prevalent in Bulgaria.

ORIG. PUB. : Izv. In-ta rastoniyev"datvo. B"lg. AN, 1958, kn. 5,

125-143.

ADSTRACT

The following weeds of the pulse family have been found in Bulgaria: vetch, vetchling, melilot, clover, alfalfa, trigonella, peas, birdsfoot trafoil, meadow clover and milk vetch. Encountered as weeds are 49 species of 10 genera out of which 23 species are of foremost importance. In addition, ther: wors found as weeds: Trifolium Balansas Boiss., T. resupinatum L., Y. nigrescens, T. Moliniery B. T. orbicularis all. after the plealing-up of a number of merdous and postures in the southern ragions of the country, these weeds become the contaminators of the grain crops. It is recommended to destroy them in the sowings of the latter by the herbicide 2.4-D.

KOLEV, K.

"Capital investments in the ore-mining industry."

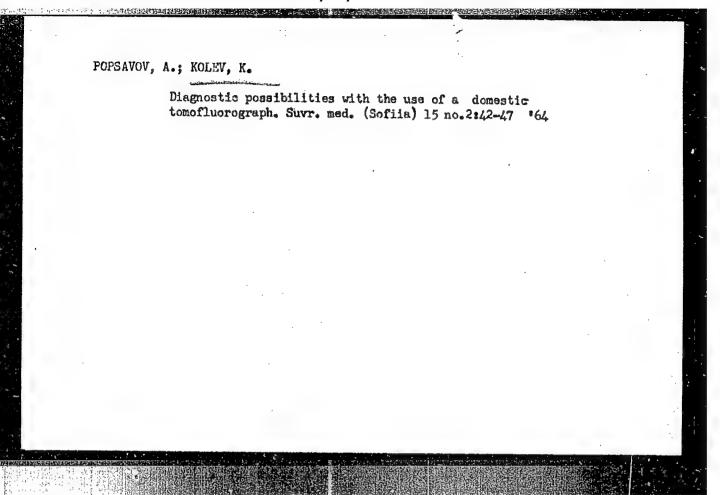
p. 43 (Minno Delo, Vol. 13, no. 2, 1958, Sofiia, Bulgaria)

Monthly Index of East European Accessions (EEAI) LC, Vol. ?, no. 9, September 1958

KOLEY, K., insh.; MINKOV, M., insh.; SAPUNDZHIEV, V.

How we reconstructed the 50-ton open-hearth gas furnace of the Lenin Matallurgic Plant into a mazut-fueled one. Min delo 17 no.9:34-37 S \*62.

l. Metalurgicheski zavod "Lenin".



KOLEV, Koliu, inzh.

C) Lo Introduction Control Con

Continuous cleaning of condenser tubes with rubber balls. Elektroenergiia 14 no.2:27-28 F \*63.

GAITANDZHIEV, Georgi; KOLEV, Kol'o; OCNIANOV, Dimitur, KHRISTOFOROV, Liubomir.

Quality of the anthrax vaccine produced in Bulgaria, and results of its application after the Max Sterne method. Selskostop nauka 1 no.10:1131-1140 62.

(MIRA 16:2)

STOYCHEV, Lyuben Iv. [Stoichev, Liuben IV], dots., arkhitektor, doktor landshaftnogo iskusstva; KOLEV, K.M., inzh.[translator]; KORDUNYAN, N.N.[translator]; BOGOYAVLENSKIY, Kirill, red.

[Parks and landscaping] Parkovoe i landshaftnoe iskusstvo.
Sofia, Zemizdat, 1962. 385 p. Translated from the Bulgarian.

(Parks) (Landscape architecture)

KOLEV, K.S.

Metallorezhushchii instrument i ego ratsionao'noe ispol'zovanie. Dzaudzhikau , Gos. izd-vo Severo-Osetinskoi ASSR, 1948. 71 p. diagrs.

Bibliography: p. (70)

The metal-cutting tool and its efficient use.

DLC: TJ1230.K7

SO: Manufacturing and Mechanical Engineering in the Soviet Union, Library of Congress, 1953.

KOLTV, K. S.

Kolev, K. S. "Transverse vibration of smooth cylindrical parts michined between centers, "Trudy Sev.-Kavk. gorno-metallurg. in-ta, Issue 6, 1949, p. 21-25

SO: U-4934, 29 Oct 53, (Letopis 'Zhurnal 'nykh Statey, No. 16, 1949).

## KOLEV, K. S.

Vibratsii pri obrabotkė metallov rezaniem i mery beb by s nimi. Dzawizhikau, Gosidat Severo-Osetinskoi ASSR, 1950. 108 p.

(Vibrations during metal-cutting operations and measures for their prevention.)

SO: Manufacturing and Mechanical Engineering in the Soviet Union, Library of Congress, 1953.

KOLEV .K.S.

Heasuring deformation in the determination of residual stresses. Zav.lab.21 no.6:750 '55. (MLRA 8:9)

1. Severo-Kavkasskiy gorno-metallurgicheskiy institut
(Strains and stresses) (Deformations (Mechanics))

SOV/124-57-4-4981

Translation from: Referativnyy zhurnal. Mekhanika, 1957, Nr 4, p 147 (USSR)

AUTHOR: Kolev, K.S.

TITLE: On the Problem of the Stress Analysis of Cutting and Boring Tools

(K voprosu rascheta reztsov i sverl na prochnosť)

PERIODICAL: Tr. Severo-Kavkazsk. gorn-metallurg. in-ta, 1956, Nr 12, pp 80-

103

ABSTRACT: Bibliographic entry

Card 1/1

KOLEV, K.S., dots., kand. tekhn. nauk.

Effect of temperature on the precision of machined parts.

Vest.mash. 38 no.10:64-66 0 '58. (MIRA 11:11)

(Metal cutting)

25(1)

PHASE I BOOK EXPLOITATION

sov/2598

# Kolev, Konstantin Stepanovich

Novyye metody obrabotki metallov rezaniyem (New Methods of Metal Cutting) Moscow, Izd-vo "Znanyye," 1959. 29 p. (Series: Vsesoyuznoye obshchestvo po rasprostraneniyu politicheskikh i nauchnykh znaniy. Seriya IV, 1959, Nr 14) 42,500 copies printed.

Sponsoring Agency: Vsesoyuznoye obshchestvo po rasprostraneniyu politicheskikh i nauchnykh znaniy.

Ed.: T.F. Islankina; Tech. Ed.: Ye.V. Savchenko.

PURPOSE: This booklet is intended for workers and technicians in metal-cutting shops.

COVERAGE: Tool materials and their use are discussed, as well as metal-cutting machine tools and their modernization. The modern methods used in metal-cutting technique (the fastening of carbide blades, selection of tool geometry, group machining, etc.)

Card 1/2

KOLEV, K.S., kand.tekhn.nauk, dots.; KOLEV, N.S., kand.tekhn.nauk, dots.

Dynamic rigidity of the system machine tool-attachment-cutting tool-workpiece. Vest.mash. 40 no.2:50-53 F 60. (MIRA 13:5)

(Metal cutting)

11100

25239

S/122/60/000/002/009/018 A161/A130

AUIHORS:

TIPLE:

Kolev, K. S.; Kolev, N. S.; - Candidates of Technical Sciences.

•

The dynamic rigidity of the technological system

PERIODICAL: Vestnik mashinostroyeniya, no. 2, 1960, 50 - 53

TEXT: A new method is suggested for determining the dynamic rigidity of machine tools or their separate component elements, in view of the inadequacy of the two methods being used - statical and shop method. The authors point out that the system machine tool - attachement - tool - workpiece ("SPID", abbreviation for "stanok - prisposobleniys - instrument - detal?") are working under varying dynamic loads, and in statical rigidity determination the test is by applying constant loads to machine tools standing idle. The "proizvodstvennyy method" (shop method) is also not perfect. The essence of the suggested new method is the use of a dynamic factor, it, which is determined empirically [Ref. 5: K. S. Kolev, Opredeleniye progibor i uprogish otzhatiy rezaniya, (Determination of bending and elastic receding of a workpiece under the dynamic effect of the cutting force), Trudy Severo-Kavkazskogo gorno-metallurgicheskogo instituta, vyp. 14, 1957]. The dynamic factor

Card 1/3

25239 S/122/60/000/002/009/018 A161/A130

The dynamic rigidity of the technological system

had been determined in an experimental investigation, mainly on lathes, and measured with a mechanical BP-1 (VR-1) vibrograph and an electric dynamometer. The frequency and period of the workpiece vibration, static receding  $(f_{cm})$ , vibration amplitude ( $\Delta f$ ), dynamic receding  $(f_{\tilde{g}} = f_{cm} + \Delta f)$  and the dynamic factor  $\frac{f_{\tilde{g}}}{f_{cm}} = 1 + \frac{\Delta f}{f_{cm}}$  could be easily found from vibrograms and oscillograms. The  $\mu$  factor is varying in a wide range under the effect of different cutting conditions, tool geometry and holding of the workpieces on the machine tool. For instance, it varied from 1.151 to 1.610 in the turning process on a workpiece installed in centers with an increase it and the cutting conditions.

Tactor is varying in a wide range under the effect of different cutting conditions, tool geometry and holding of the workpieces on the machine tool. For instance, it varied from 1.151 to 1.610 in the turning process on a workpiece installed in centers with an increase in cutting from 8.9 to 289.18 m/min, and from 1.138 to 1.476 in turning process on a part attached in the chuck by one end and on the tailstock center by the other. It is recommended to use the following  $\mu$  values for vibration-free turning - 1.2 for finish turning, 1.3 for semi-finish, and 1.5 for rough. For turning with vibration  $\mu$  must be 2 or higher. As stated in investigations, the pulsations from the cutting forces and the not perfect rigidity of the machine tools make the bending and receding of the workpieces dynamic instead of static, and the receding increases with the increasing  $\mu$  factor. This applies not only to lathes but to all chip-removing machine tools, and particularly to machine tools

Card 2/3

25239

The dynamic rigidity of the technological system

S/122/60/000/002/009/018 A161/A130

working with intermittent cutting with impacts. There are 6 figures and 5 Sovietbloc references.

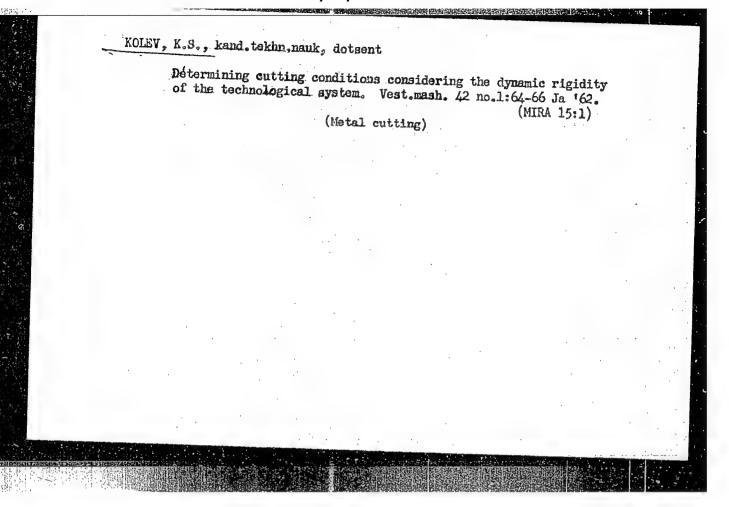
Card 3/3

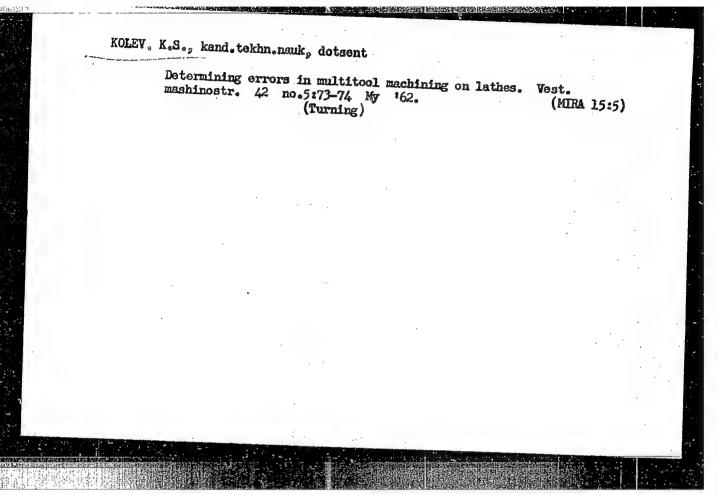
KOLEV, Konstantin Stepanovich, dotsent, kand. tekhn. nauk; DASHEVSKIY, T.B., kand. tekhn. nauk, red.; NIKIFOROVA, R.A., inzh., red.; GORNOSTAYPOL'-SKAYA, M.S., tekhn. red.

[Problems of precision in cutting metals] Voprosy technosti pri rezanii metallov. Moskva, Gos. nauchno-tekhn. izd-vo mashinostroit. lit-ry, 1961. 131 p. (MIRA 14:9)

KOLEV, K. S.

Doc Tech Sci - (diss) "Problems of precision in cutting metals."
Moscow, 1961. 29 pp; (Ministry of Higher and Secondary Specialist
Education RSFSR, Moscow Machine-Tool Inst imeni I. V. Stalin);
200 copies; price not given; list of author's works on pp 28-29
(21 entries); (KL, 6-61 sup, 211)





KOIEV, K.S., kand.tekhn.nauk, dotsent

Effect of the gyroscopic effect on the precision of machining on lathes. Vest.mashinostr. 43 no.2:59-61 F '63. (MIRA 16:3) (Turning)

KOLEV, K.S., kand.tekhn.nauk, dotsent

Determining total error in automatic machining of parts. Veat.
mashinostr. 44 no.1:71-73 Ja '64. (MIRA 17:4)

POPOV, G.; STOYKOV, M.; IVANOV, A.; GOSPODINOV, B.; SEDLOYEV, S.;
STOYANOV, Ye.; VOLGHANOVA, S.; KOLEV, L.

Extracardial amastomoses in congenital and acquired heart defects in experiment. Khirurgiia 36 no.3:38-41 Mr \*60.

(HEART—SURGERY)

(MIRA 13:12)

CHAUSHEV, T.; VELEV, N.; KOLEV, L.

Tuberculum sulgentium as an occupational disease. Suvrem. med.,
Sofia 7 no.4:117-121 1956.

1. Iz Okrushniia kozhno-venerologichen dispanser--Stara Zagora
(G1. lekar: T. Chaushev)
(VIRUS DISEASES,
milker's nodes (Bul))

DIMITROV, D.; GENOV, Iv.; IRDANOV, I.; DAVIDOV, S.; KOLEV, L., inzh.; ZOGRAFOV, Iv., inzh.

Preliminary data on experimental studies on extracorporeal circulation with our apparatus. Khirurgiia 15 no.9/10:895-899 162.

1. Iz Katedrata po propedevtika na khirurgichnite zaboliavanija pri VMI [Vissh meditsinski institut] - Sofija. (HEART MECHANICAL)

KOLEV, M.

KOLEV, M. Combined forage. p. 29

Vol. 11, no. 7, July 1956 KOOPERATIVNO ZEMEDELIE AGRICULTURE Sofiia, Bulgaria

SO: East European Accession, Vol. 6, No. 3, March 1957

Koley M.

BULGARIA / Chomical Technology. Chomical Products and Their Application. Leather. Fur. Gelatin. Tanning Materials. Industrial Proteins.

Abs Jour: Ref Zhur-Khimiya, No 9, 1959, 33675.

: Ivanov, D., Kolev, M. Author Inst : Not given.

Titlo : Obtaining Hydrogen Sulfide and Carbon Dioxido

Absorbors by the Alkaline Hydrolysis of Wasto

Albuminous Substances.

Orig Pub: Tozhka promishlenost, 1957, 6, No 10, 18-23.

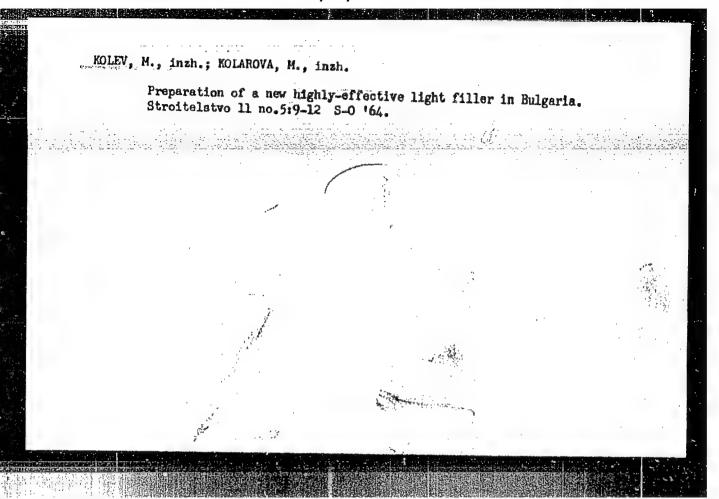
Abstract: The application of amino acids as absorbing

agents may be substituted by mixtures of natural amino acids, obtained by an alkaline hydrolysis of albuminous substances - horny koratin (alkacido PA); the properties of the latter are similar to the properties of the alkacide

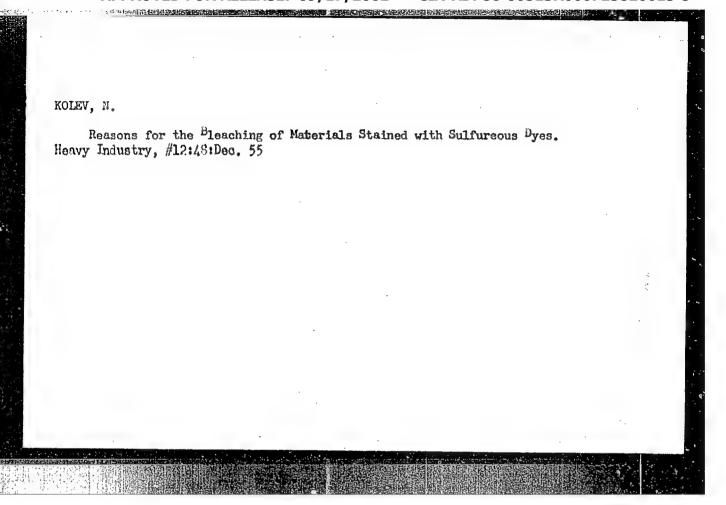
DIK. -- Ye. Stefanovskiy.

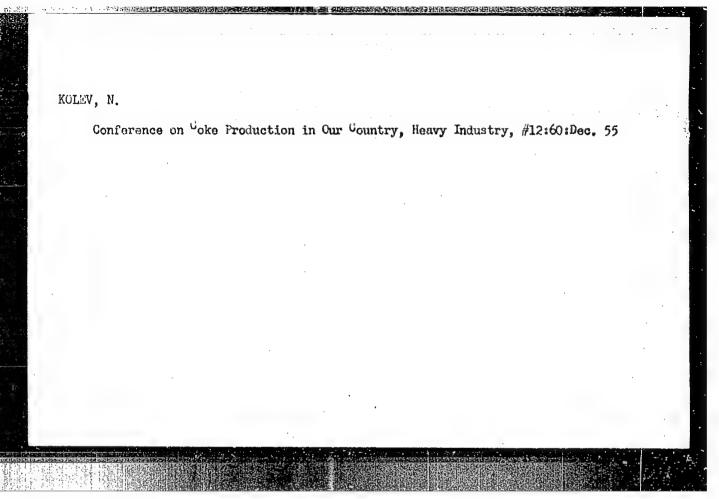
Card 1/1

310



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KOLEV, N.

New Books about Technical Standardization in the Coal Industry. Heavy Industry, #12:64:Dec. 55

KOLEY, N.

Automatic hydroelectric power plants. p. 9. ELEKTROENERGHIA, Sofiya, Vol. 6, no. 3/4, Mar./Apr. 1955.

SO: Monthly List of East European Accessions, (EEAL), LC, Vol. 4, no. 10, Oct. 1955, Uncl.

		Н-6
OUNTRY:	3 Bulgaria	
ategary aes. Jour.	2 RZKhim., No. 5 1960, No.	18386
AUTHOR INST. TITLE	<ul> <li>Kolev, N.</li> <li>Not given</li> <li>Studies on the Production of A Liquitor for Fire-Fighting Applications</li> </ul>	
CRIG. FUB.	Khimiya i Industriya (Bulgaria), 3. (1959)	1, No 2, 39-44
ABSTRACT	* No abstract.	
CARD: 1/	ı	

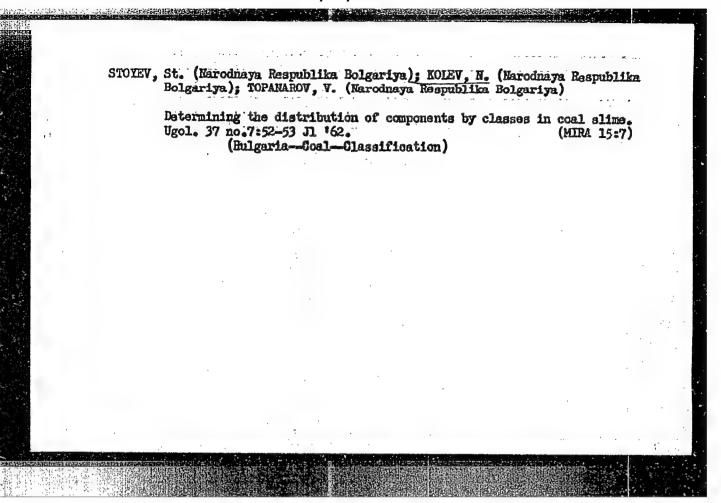
# APPROVED FOR RELEASE 09/47/2001; KOLCTAIR DESG. 00513R000723820013-5"

Coal dressing, a means of cost reduction in industrial production. Min delo 18 no. 2:16-20 F 163.

KRUSTINOV, G., prof.; KAZANDZHIEV, R.; KOLFV, N.; BELEV, V.; TONEV, B.

Our experience with the use of a film-forming substance in the treatment of burns. Khirurgiia 17 no.2:150-152 \*64.

1. Iz Visshiia voennomeditsinski institut, Sofiia.



KOLEV, N.; KILIMOVA, L.; ZHUROVSKA, N.

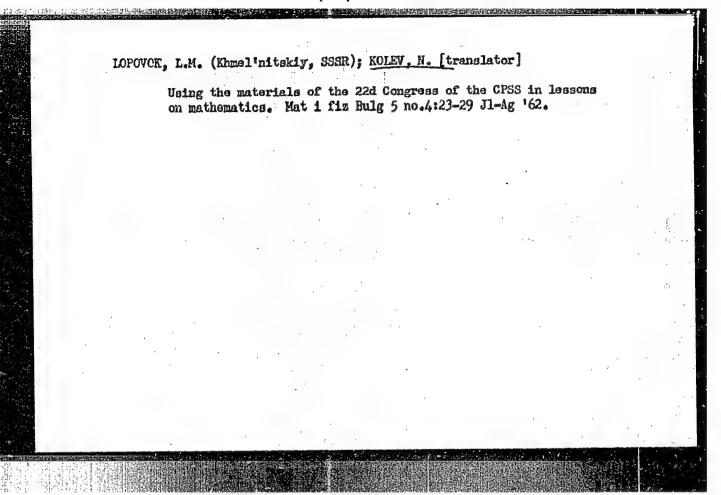
Oxidation of ethylene up to ethylene oxide. Khim i industriia 34 no.2:64-69 162.

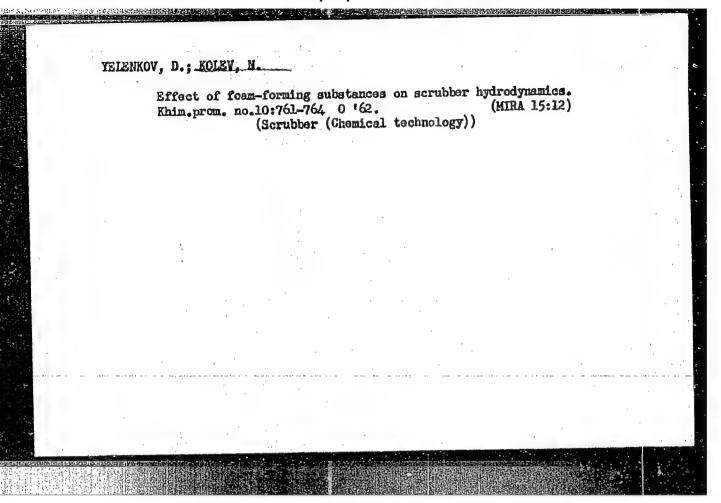
KOLEV, N.; KURTEVA, R.

Radial chromatography of sulfuric dyes. Khim i industriia 34 no.3:89-91 62.

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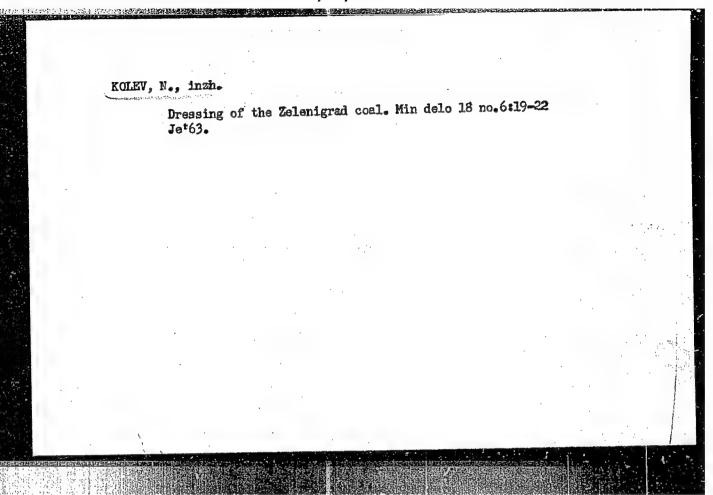




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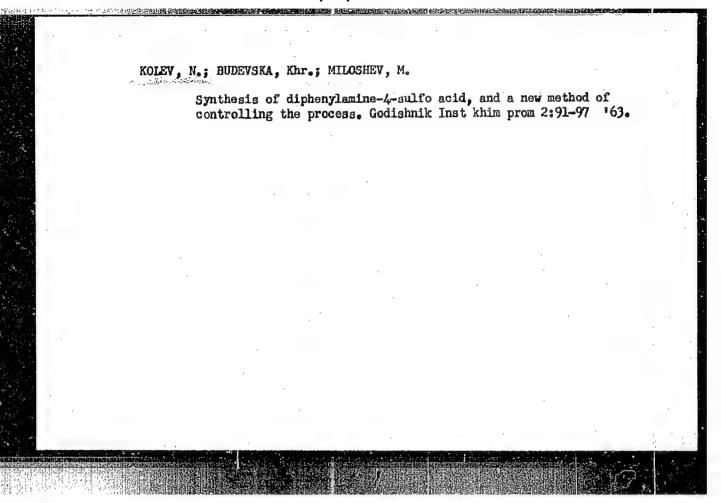
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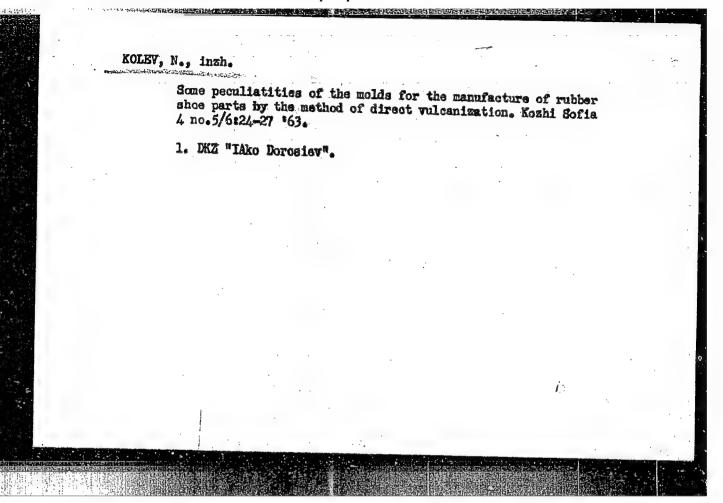
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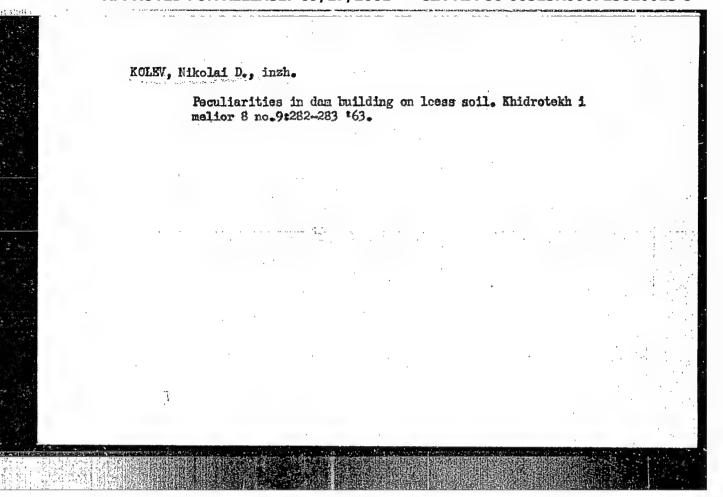
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Pash, Politabmichash Amalohash Panichash Panic	PALSE I BOOK EXPLOITATION SOV/4221	,	Eliforial Board: V.P. Milhajlor (Sap. Ed.), Candidate of Technical Sciences, Docust, L.A. Frankishigh, Professory; P.N. Vasor, Candidate of Technical Elaments, Docust, I.M. Conduct Candidate of Technical Sciences, Docust, Candidate of Technical Sciences, Docust, Candidate of Technical Sciences, Docust, and A.L. Ekthior (Ess.) Seria, Candidate of Technical Sciences, Docust, 18th. Estimo (Ess.), Seria, Candidate of Technical Sciences, Docust, 18th. Seria, Candidate of Technical Sciences, Docust, 18th. Estimo (Ess.), Seria, Candidate	FURFORM: This book is intended for technical personnel in sechanical excineering.  OFFRIGHT: This soliection of work deals with investigations of internal conhustry match contains, false station of internal conhustry match.	- served at the stations to be parallels are sentioned. References accompany district. A Tailou in the Metal-Cutties process The sather berilly reverse some of the date scalable on the subject and French the results of an invasigation of the affect of cutting depth and French facts and both angles on the cutting process. The conditions that in Furthers has a great affect on the cutting brokens on the conditions that in Furthers has a great affect on the cutting brokens ontitue/col and work	Paring 1.P. [Docent, Department of the Theory of Mechanias and Machine Transfer, Lond-Carryling Canadity of Tombad George Made of Days of Machine The antibate Artists of Tombad George Made of Days of Tombad George Made of Days of Tombad Man Market of Days of Made of Days of Tombad Man Market of Days of Market of Days	forming the graph of the specially built test installation is order to determine the effort of mander of test, who defined and the test installation and elvorages that make the definition of generality on the performance of a pair of generality one gray made of steal presents (From of the test of test). The maximum elvoragemental unit failure of the test of test to the defort which no specially order that of sear or expectable as a sirvariant of the test of	Chamber, F.A. [Assistant Professor, Department of the Theory of Ferbanians and Manine Farts]. Parternance of the Wire Grid of a Resistance-Type Strain Effect of Comparture on the resistance of a strain and control of the new that the rate of Phage in the Professor of the new that the rate of Phage in the resistance is a forest. The of the and heating temperature, It decreases with time and heating to the Phage in the	Children V.A. Affect of the Chap of the Mrs Grid of a Resistance-Type Affects of the Table of the Paris.  Effects of Pars had been, another had not a first wires, deformation of wires in the Mrs thank extends and the maker of grid loops on the Cart force of the Mrs thank affect and the maker of grid loops on the Cart force of the Mrs thank affect and the maker of house the Mrs thank affect and its area.	Satin. 11.1. [Senior Instructor, Department of the Theory of Pechanisms and The ware of serving the Estimates of Servine Sating Serving the Estimates of Servine Section 199 square and temperature of Percentages of Servine and temperature of the Servine S	Mark A.E. [Assistant Frifessor, Uppertagnt of Noral Technology and the Meiore of Setally A. Rishol of Leafping Uppertagnt Cears Mith Strender Cook Form The method described reduces datapp calculations and may be used in the de- sign of Appeld great with a spiral angle squal to sero.	Mendishange, i.g., [Assistant Professor, Superisent of the Teacy of Sechasima and Meahins Paris). In the Problem of Stellisty in the Tigitaning of Boltes! The subtar Francis the Frenits of a theorytical livestigation of the pro-	**************************************
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Kolev, N. S.; - Candidates of Technical Sciences, Docents.

TITLE: The dynamic rigidity of the technological system

/estnik mashinostroyeniya, no. 2, 1960, 50 - 53 PERIODICAL:

TEXT: liew method is suggested for determining the dynamic rigidity of machine tools or their separate component elements, in view of the inadequacy of the two methods being used - statical and shop method. The authors point out that the system machine tool - attachement - tool - workpiece ("SPID", abbreviation for "stanok - primposobleniya - instrument - detal?") are working under varying dynamic loads, and in statical rigidity determination the test is by applying constant loads to machine tools standing idle. The "proizvodstvennyy method" (shop method) is also not perfect. The essence of the suggested new method is the use of a dynamic factor, /1, which is determined empirically [Ref. 5: K. S. Koley, Opredeleniye progibor i uprogikh otzhatiy rezaniya, (Determination of bending and elastic receding of a workpiece under the dynamic effect of the cutting force), Trudy Severo-Kavkazskoge gorno-metallurgicheskogo instituta, vyp. 14, 1957]. The dynamic factor

Card 1/3

The dynamic rigidity of the technological system

had been determined in an experimental investigation, mainly on lathes, and measured with a machanical BP-1 (VR-1) vibrograph and an electric dynamometer. The frequency and period of the workplace vibration, static receding (fom), vibration amplittade (at), dynamic recoding (for fem + at) and the dynamic factor  $\mu = \frac{f'}{f_{cm}} = 1 + \frac{\Delta l'}{f_{cm}}$  could be easily found from vibrograms and oscillograms. The  $\mu$ factor is varying in a wide range under the effect of different cutting conditions, tool geometry and holding of the workpieces on the machine tool. For instance, it varied from 1.151 to 1.610 in the turning process on a workpiece installed in centers with an increase in cutting from 8.9 to 289.18 m/min, and from 1.138 to 1.476 in turning process on a part attaheed in the chuck by one end and on the tailstock center by the other. It is recommended to use the following  $\mu$  values for vibrationfree turning - 1.2 for finish turning, 1.3 for semi-finish, and 1.5 for rough. For turning with vibration  $\mu$  must be 2 or higher. As stated in investigations, the pulsations from the cutting forces and the not perfect rigidity of the machine tools make the bending and receding of the workpieces dynamic instead of static, and the receding increases with the increasing A factor. This applies not only to lathes but to all chip-removing machine tools, and particularly to machine tools

Card 2/3

The dynamic rigidity of the technological system

Working with intermittent cutting with impacts. There are 6 figures and 5 Sovietbloc references.

Card 3/3